

ship Dec 16

Work Order ID 152450

152450

Page 1

Monday, October 24, 2016 11:41:26 AM

Item ID: D119-796-021 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection
Start Date: 11/17/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: OCT 24 2016 Tooling: _____ Date: _____ Run Start *NR1*
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D119-796-021	A
IIN-D119-796	E

100	Pick Kit	0.00				<u>DAS 6</u>		<u>DEC 05 2016</u>
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100

Packaging

Memo

0.00

Packaging

Photocopy bluefile and create labels as per PPP D119-796-021 chg 003/ D119-646-041 paperwork

110		0.00						
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110

HandFinish

Memo

1.16

Hand Finishing

ASSEMBLE AS PER DWG AND NOTES 8,9,10,11

ASSEMBLE WITH PROSEAL BATCH: 136076

2-INSTALL DECAL D2729-4

1X 16/2/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coor. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
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152450

Monday, October 24, 2016 11:41:26 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/17/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/15/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00
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120

OC

Quality Control

Memo

0.08

Identify as per dwg & Stock Location: Shop 0.00

130

130

Packaging

Packaging

Memo

0.04

Identify and pack for shipping as per PPP D119-796-021

Location:

PPP Rev: _____

140

QC21- Final Inspection - Work Order Release	0.00
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140

OC

Quality Control

Memo

0.02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition			
				Completed By _____			
				Lead hand / Supervisor Approval Verification _____			
				QC / QA Coordinator Approval _____			

Root Cause				FAULT CATEGORY			
Environment	☐	☐	No Re-verification	☐	☐	☐	Pressure/Forced
Design	☐	☐	Operator	☐	☐	☐	Temperature/Cure
Doc/Data	☐	☐	Offset/Setup	☐	☐	☐	Set-up
Equip/Tooling	☐	☐	Supplier	☐	☐	☐	BOM/Route
Handling/Pre	☐	☐	Training	☐	☐	☐	Cracks
Material	☐	☐	Use for Testing	☐	☐	☐	Crimp/Kink/Ripple/Wave
Internal Transport	☐	☐	Poor Information	☐	☐	☐	Cuffs
Tribal Knowledge	☐	☐	Rushing	☐	☐	☐	Crushing
LOA	☐	☐	Product Improvement	☐	☐	☐	Heat Treat
Substation	☐	☐	Process Improvement	☐	☐	☐	Wave/Twist in Tube
Past Expiry Date	☐	☐	Manufacturing Process	☐	☐	☐	Marks/Chatter
Misidentified	☐	☐	Past Due	☐	OTHER : _____		

Picklist Print

Monday, October 24, 2016 11:41:25 AM

Page 1

Work Order ID: 152450

152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD IPP
REV:B 15.08.25 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-041		Manufactured	No			110	Each	2.0000	2	2			
D119-646-041									**				
AW119 Replacement Skidtube with Wearpads - Fits LH or RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					
				148125				1					
				148126				1					
D119-796-151		Manufactured	No			110	Each	2.0000	1	1			
D119-796-151									**				
FWD Crosstube Installation with Step (no hardware)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					
				151304				1					
				151305				1					
D119-796-251		Manufactured	No			110	Each	2.0000	1	1			
D119-796-251									**				
AFT Crosstube Installation with Step (no hardware)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					
				151308				1					
				151309				1					

16/12/12 *[Signature]*
B152443 (1x)

B152444 (1x)
DAS 36 9-89
16/12/13

B151004 (1x)

16/12/13
DAS 36 9-89

B150986 (1x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Monday, October 24, 2016 11:41:25 AM

Page 2

Work Order ID: 152450

152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110

Each

364.0000

48

48

D2652

Bushing

**

15098

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

44

31985

44

ST009

320

149586

6

149681

108

149828

206

D3407-041

Manufactured No

110

Each

14.0000

2

2

D3407-041

Tow Ring

**

152870

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

st530

14

148623

5

151431

9

D3417-5

Manufactured No

110

Each

103.0000

4

4

D3417-5

Washer

**

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST035

23

148700

23

ST038A

80

149255

40

151493

40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____																																																															

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Work Order ID: 152450

152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

64.0000

2

2

D3456-1

Washer

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST037

57

149551

7

150652

50

2

D3672-3

Manufactured No

110

Each

1,244.000

48

48

D3672-3

Washer, Phenolic

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

213

132639

213

ST049

431

149295

431

ST051A

500

151298

500

4.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																							
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Work Order ID: 152450

152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

110

Each

837.0000

48

48

D3672-7

Washer, Phenolic

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST049

297

149431

297

ST051A

500

150867

500

48

D3883-1

Manufactured No

110

Each

11.0000

2

2

D3883-1

Saddle, Outboard LH

151794

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

11

149593

5

150424

6

D3883-2

Manufactured No

110

Each

8.0000

2

2

D3883-2

Saddle, Outside RH

151815

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

8

149623

8

D3884-1

Manufactured No

110

Each

11.0000

2

2

D3884-1

Saddle, Inside LH

152394

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

11

149519

6

150158

5

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

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Work Order ID: 152450

152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3884-2

Manufactured No

110

Each

8.0000

2

2

D3884-2

Saddle, Inside RH

**

151280

DEC 05 2016 DAS 6 9-89

Location

Loc Qty

Loc Code

ST404

8

149576

2

150388

6

D3886-041

Manufactured No

110

Each

3.0000

4

4

D3886-041

Lug Assembly

**

3X 151001

DEC 05 2016 DAS 6 9-89

1X 152469

Location

Loc Qty

Loc Code

ST528

3

149596

3

AN3C46A

Purchased No

110

Each

114.0000

8

8

AN3C46A

Bolt

**

136055

DEC 05 2016 DAS 6 9-89

Location

Loc Qty

Loc Code

FG

10

122843

10

ST346

104

134795

70

M132522

33

M134794

1

AN3C50A

Purchased No

110

Each

0.0000

16

16

AN3C50A

Bolt

**

136025

DEC 05 2016 DAS 6 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Work Order ID: 152450

152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

405.0000

24

24

AN4C6A

Bolt

DEC 05 2016
DAS
6
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

220

m135470

145

m135603

75

ST345

171

m135297

10

m135470

161

30

MS21043-3

Purchased

No

110

Each

1,340.000

24

24

MS21043-3

Nut

DEC 05 2016
DAS
6
9-89

Location

Loc Qty

Loc Code

CCK007

400

m135864

400

FG

80

103691

80

FP001

11

m130673

11

GA

133

m133990

133

OVER007

400

m135704

400

ST302

247

m135544

247

ST304

69

m131340

69

24

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER :																					

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Monday, October 24, 2016 11:41:26 AM

Work Order ID: 152450

152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

811.0000

26

26

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

ST302

754

m135530

254

m135600

500

DEC 05 2016 ^{DAS} 6 ₉₋₈₉

MS21043-5

Purchased

No

110

Each

199.0000

8

8

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

71

116548

71

ST302

108

m135704

108

DEC 05 2016 ^{DAS} 6 ₉₋₈₉

MS21250-05048

Purchased

No

110

Each

70.0000

8

8

MS21250-05048

Bolt (use MS21250-05-048)

Location

Loc Qty

Loc Code

over006

30

m135841

30

ST295

40

m135482

5

m135664

35

DEC 05 2016 ^{DAS} 6 ₉₋₈₉

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 152450

152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

3,876.000

24

24

NAS1149C0332R

WASHER

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

344

m135274

344

GA

86

m133284

86

ST260a

2000

m135466

1000

m135672

1000

ST266

1446

m135408

746

m135766

500

m135908

200

24

NAS1149C0432R

Purchased

No

110

Each

1,185.000

48

48

NAS1149C0432R

WASHER

135979

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

800

m125807

427

m134676

373

ST266

385

m135544

385

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
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Picklist Print

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152450

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 11/17/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

110

Each

469.0000

16

16

NAS1149C0532R

WASHER

**

DEC 05 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

60

116513

60

ST260a

200

m135390

200

ST266

209

m135671

193

m134756

16

139x89x35crate

Purchased

No

110

Each

0.0000

1

1

139x89x35crate

Agusta Crate

MS21920-28

Purchased

No

Each

121.0000

2

MS21920-28

Clamp

**

16/12/15

**

DEC 05 2016
DAS
6
9-89

Location

Loc Qty

Loc Code

FG

1

105884

1

LG050

112

M135009

37

M135774

25

M135859

50

LG051

1

M132169

1

LG057

2

M134130

2

st543

5

M135007

5

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